


SCALE 2X

- NOTES:
1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
  2. MAKE FROM MCD'S NONROTATABLE VACUUM FLANGE  
CAT. #110030
  3. WHEN MACHINING VACUUM PARTS, USE OF  
SILICONE AND SULPHUR-BASED CUTTING FLUIDS  
IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
  4. FINISHING: WHEN MACHINING VACUUM PARTS USE OF  
ABRASIVE PAPER OR SANDING DISCS, BUFFING OR  
POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING  
WHEELS IS PROHIBITED
  5. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT  
A UHV PRESSURE OF  $1 \times 10^{-9}$  TORR CAN BE ACHIEVED
  6. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH  
WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL  
TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
  7. DIMENSIONS IN [ ] ARE MILLIMETERS AND  
FOR REF. ONLY

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DECIMALS      ANGLES X      ± .1 (2.5) XX     ± .01 (0.25) XXX   ± .005 (0.13)		THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>		
SURFACE ROUGHNESS 125 ✓ REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1 DIMENSIONS TO BE IN ACCORDANCE WITH LATEST ANSI Y14.5		P8620201-00  DRAWN BY MUSCIA DATE 12/23/98 CHECK DESIGN ENGINEER D. Shu DATE 1/27/98 TITLE <b>ADVANCED PHOTON SOURCE</b> P8-60 I.D. MONO. INTEGRAL SHUTTER LOWER BELLOWS FLANGE DESIGNED BY CHANG/MUSCIA DATE 12/23/97 PROJECT MGR. J. CHANG DATE 1/23/98 APPROVE/DRELEASED		
MATERIAL SEE NOTE #2		SCALE    HALF SHEET 14 C DRAWING NUMBER P8-620201-00		